

**Work Order ID 51563**

August 26, 2009 10:17:43 AM

*ASAP***PRELIMINARY ISSUE**

Page 1

Item ID: D3956-3  
Revision ID: A-PRELIM  
Item Name: Hinge, Airframe Lower

Accept



Setup Start



Stop



Start Date: 8/26/09 Start Qty: 1.00  
Required Date: 8/27/09 Req'd Qty: 1.00



Cust Item ID:  
Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
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D3956	A-PRELIM
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100

0.00



Waterjet

FLOW CNC Waterjet

Memo

1-Cut as per Dwg D3956

Dwg Rev: PREProg Rev: LIM

2-Deburr if necessary

0.00

*IB 9-8-26*

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Quality Control

Memo

0.00

*IB 9-8-26**①*

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Page 2

Item ID: D3956-3

Accept

Revision ID: A-PRELIM

Item Name: Hinge, Airframe Lower

Start Date: 8/26/09 Start Qty: 1.00

Required Date: 8/27/09 Req'd Qty: 1.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

130

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

140

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Memo

0.00

Powder Coating

Start Time: \_\_\_\_\_  
Oven Temperature: \_\_\_\_\_  
Finish Time: \_\_\_\_\_

N/A per ECN 09-650P U

08-08-27

=> Hl 08/08/27 1 0

# Work Order ID 51563

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Page 3

Item ID: D3956-3

Accept

Revision ID: A-PRELIM

Item Name: Hinge, Airframe Lower

Start Date: 8/26/09 Start Qty: 1.00

Required Date: 8/27/09 Req'd Qty: 1.00

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

150

QC3- Inspect Part Finish

0.00

QC

Memo

0.00

Quality Control

160

Identify as per dwg & Stock Location:

0.00

Packaging

Memo

0.00

Packaging

170

QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

BR 09-08-27 (1)

SHIP TO HARVEY AT EAGLE - see attached email

NO QC 21 / NO COFC  
TESTING ONLY

POSITIVE RECALL  
EFFECTIVE 9/28/06  
RELEASED DATE

RDOZOR

u 09-08-27

# Picklist Print

August 26, 2009 10:17:43 AM

Page 1

Work Order ID: 51563

Parent Item: D3956-3A-PRELIM

Parent Item Name: Hinge, Airframe Lower


Comments:

Start Date: 8/26/09

Required Date: 8/27/09

Start Qty: 1.00

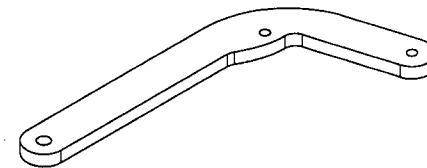
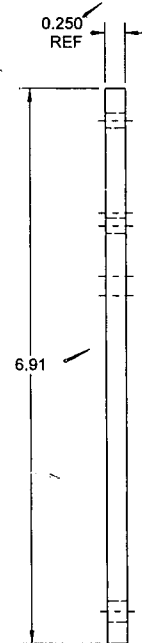
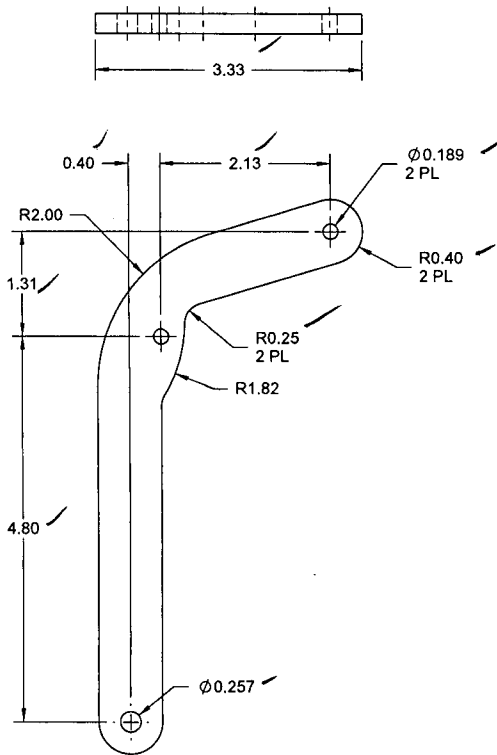
Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status	
M6061T6S.250		Purchased	No			100	sf	0.0000	0.1682				
											M 18398		KB 9-8-26
6061T6 SHEET .250													

POSITIVE RECALL  
EFFECTIVE \_\_\_\_\_  
RELEASED \_\_\_\_\_  
AUTH \_\_\_\_\_  
DATE \_\_\_\_\_

u





# **D3956-3 HINGE, AIRFRAME LOWER**

## **NOTES:**

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.250 THICK  
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027  
REF DART SPEC M6061T6S.250
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3956-3" AND B/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.16 lbs

**PRELIMINARY ISSUE**  
10/08/25

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3956	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		HINGE	NTS
DATE	09.08.24	<small>COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

60445

## L Lacelle

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**From:** Mike Petsche [mpetsche@dartaero.com]  
**Sent:** August 27, 2009 12:44 PM  
**To:** 'L Lacelle'; 'Harvey Siemens'  
**Cc:** ssheldon@dartaero.com; 'Jason Murdoch'  
**Subject:** RE: D3956-1/-3 hinges

They can go +ve recall....they are staying within DART control. For testing only. Dwgs aren't released or anything

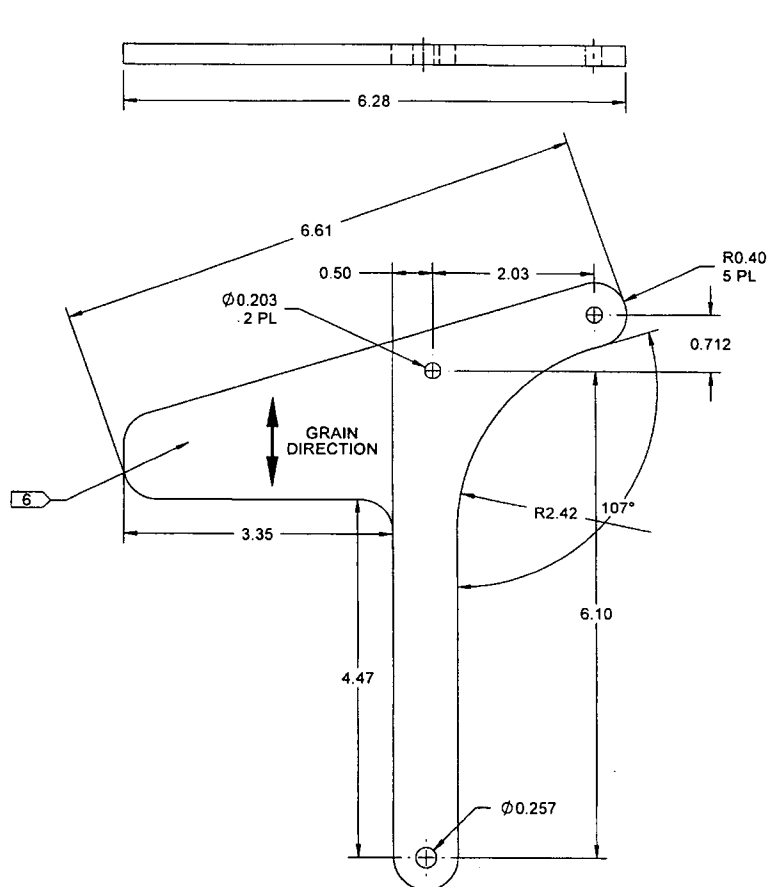
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**From:** L Lacelle [mailto:llacelle@dartaero.com]  
**Sent:** Thursday, August 27, 2009 11:18 AM  
**To:** 'Mike Petsche'; 'Harvey Siemens'  
**Cc:** ssheldon@dartaero.com; 'Jason Murdoch'  
**Subject:** D3956-1/-3 hinges  
**Importance:** High

I have 1 each of these to ship to you Harvey, and are under positive recall...is this how we are sending them out?  
I know these are rush so would need to know asap, and are there other parts to go with these?

Thank You,  
Linda Lacelle  
Production Manager  
Dart Aerospace Ltd

8/27/09










**D3956-1 HINGE, AIRFRAME UPPER**

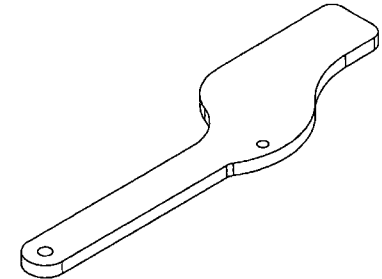
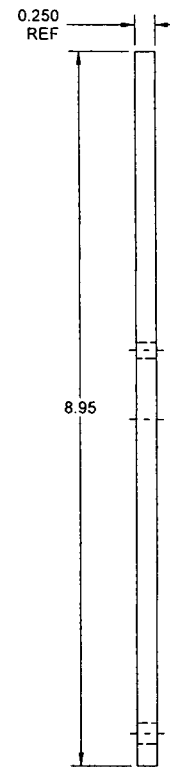
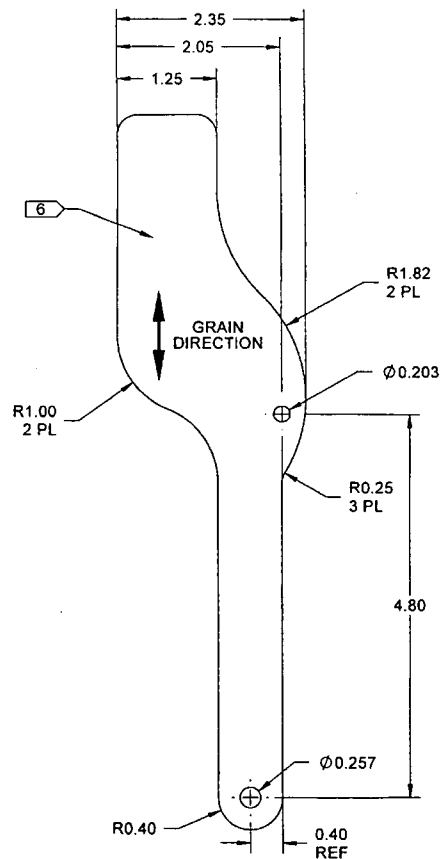
**NOTES:**

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- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3956-1" AND B/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.31 lbs

**RELEASED**  
2009 -10-08  
JH

A NEW ISSUE		BY 		09.09.14
REV.	DESCRIPTION		BY	DATE
DESIGN		<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA  DRAWING NO. <b>D3956</b>  TITLE <b>HINGE</b>		
DRAWN				
CHECKED				
MFG. APPR.				
APPROVED				
DE APPR.				
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			REV. /	SHEET 1 OF
				SCALE
				NTS





57563

**RELEASED**  
2009-10-08  
NNT

**D3956-3 HINGE, AIRFRAME LOWER**

**NOTES:**

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.250 THICK  
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- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3956-3" AND B/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.25 lbs

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3956	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		HINGE	NTS
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